

30 Nov
Work Order ID: 126634

November-19-14 9:06:26 AM

126634

Page 1

Item ID: D4092-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step

Start Date: 11/19/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/21/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: V

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

10

Ø

DAS
37
9-89

14.11.21

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA935

Dwg Rev: B

Folio rev: AA

Deburr

0.00

MR/J 14/11/22

10

Ø

***Grind flush transition machining mark after machining bottom of extrusion,
see detail A.***

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Item ID: D4092-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Maintenance Step
Start Date: 11/19/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/21/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				10	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10	0		Off 2014-11-26
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				10	0	14-11-26	2233

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Page 3

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Item ID: D4092-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step
 Start Date: 11/19/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/21/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155	Wing Walk as per dwg QSI005 4.4 Batch <u>11130289</u>	0.00							
155	HandFinish	Memo							
	Hand Finishing								

X 10 of 10 11/16/14

160	QC3- Inspect Part Finish	0.00							
160	QC	Memo							
	Quality Control								

(10) DAS 38 9-89

DEC 01 2014

170	Identify as per dwg & Stock Location: <u>5450</u>	0.00							
170	Packaging	Memo							
	Packaging								

10 DAS 86 9-89

DEC 02 2014

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Item ID: D4092-1 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Maintenance Step
Start Date: 11/19/14 **Start Qty:** 10.00 ***10*** **Cust Item ID:**
Required Date: 11/21/14 **Req'd Qty:** 10.00 ***10*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14/12/3

4-12-2

Picklist Print

November-19-14 9:06:26 AM

Page 1

Work Order ID: 126634

126634

Parent Item: D4092-1

D4092-1

Parent Item Name: Maintenance Step

Start Date: 11/19/14

Required Date: 11/21/14

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108		Manufactured	No			100	f	354.6500	2.5	27			
												DAS	
												37	
												9-89	

D2761-108

Extrusion (HPK)

14.11.21

Location

Loc Qty

Loc Code

MAT006

354.65

80206

354.65

27 44.

~~NO D2761-108 COPIES~~

DART AEROSPACE LTD		Work Order: 126634
Description: Maintenance Step		Part Number: D4092-1
Inspection Dwg: D4092	Rev: B	Page 1 of 1

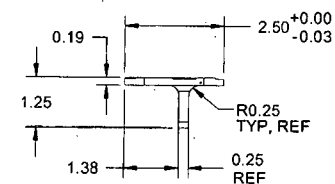
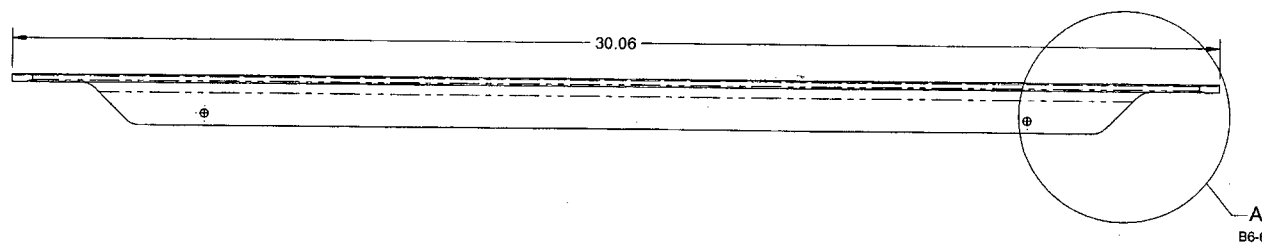
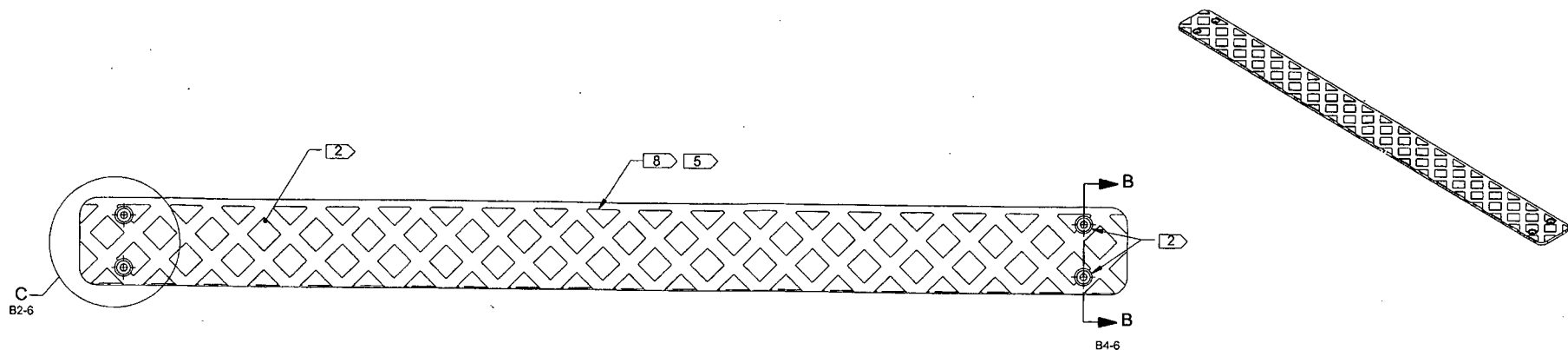
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30.06	✓		tape LP 12	
0.19	+/-0.030	.185	✓		vern LP 09	
1.25	+/-0.030	1.245	✓			
1.38	+/-0.030	1.380	✓			
0.25	+/-0.030	.247	✓			
R0.25	+/-0.030	.25	✓		Radius gauge	
2.50	+/-0.030	2.50	✓		vern LP 09	
Ø0.201	+0.005/-0.001	.200	✓		gauge pin	
0.30	+/-0.030	.300	✓		vern LP 09	
4.78	+/-0.030	4.780	✓			
1.69	+/-0.030	1.69	✓			
2.96	+/-0.030	2.96	✓			
0.030	+/-0.010	.032	✓			
0.20	+/-0.030	.201	✓			
0.50	+/-0.030	.50	✓			
0.035	+/-0.010	.039	✓			
0.390 x 100°	+/-0.010 x 0.5°	.394, 100°	✓			
1.500	+/-0.130	1.500	✓			
0.50	+/-0.030	.500	✓			
1.25	+/-0.030	1.248	✓			
0.69	+/-0.030	.687	✓			
0.38	+/-0.030	.378	✓			
0.69	+/-0.030	.686	✓			

Measured by: [Signature]	Audited by: JFL	Preliminary Approval:
Date: 14/11/22	Date: 2014-11-26	Date:

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.06.18	Dimension 2.96 was 2.69	KJ	

8 7 6 5 4 3 2 1



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

m/o 12/6/24

RELEASED
2011-09-22

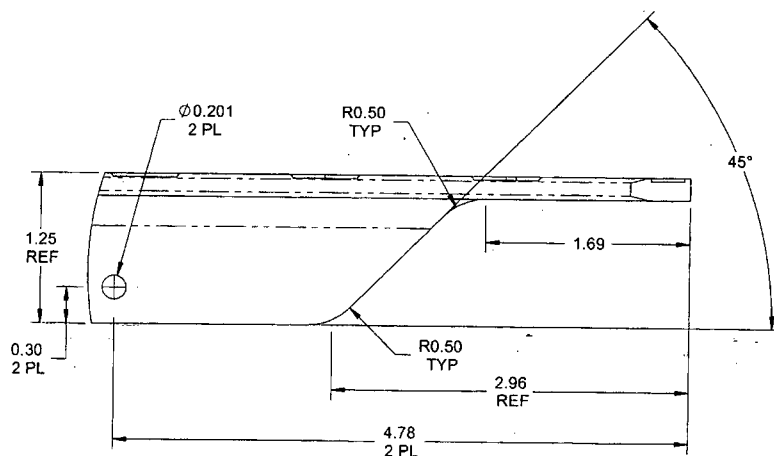
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DRAWN	RF	KENT, WA	
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MFG. APPR.	<i>RF</i>	D4092	SHEET 5 OF 6
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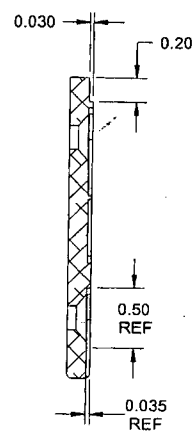
8 7 6 5 4 3 2 1

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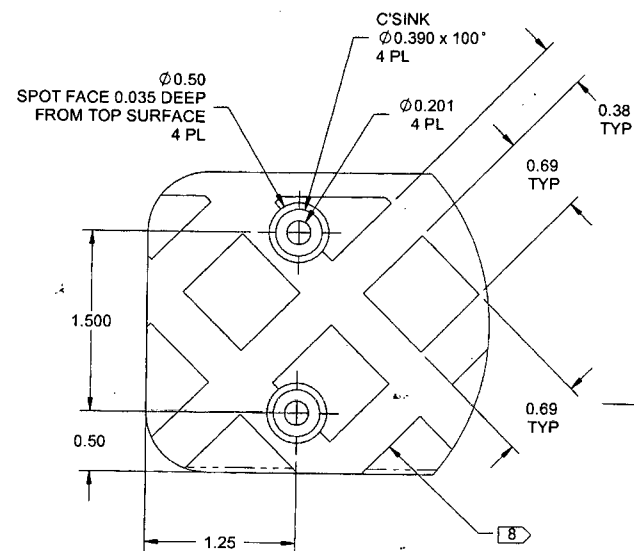
D
C
B
A



DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

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8 7 6 5 4 3 2 1

